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# UNITHERM Food Systems, Inc.

## Cooking Trial Data

Test #	Belt Speed	Cook Time	Product: TURKEY BREAST		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remark
			Temperatures C.						
			Zone 1	Zone 2					
#1	71 HZ		570°	650°				39°	30% CHARCOAL SELECT 24P COULD BE TOO DARK FOR THEM
#2	90 HZ		570°	650°				38°	30% CHARCOAL SELECT 24P
#3	90 HZ		570°	650°				38°	FRESH MIX 30% 24P
#4	103		570	650				39°	30% 24P (10 SECOND DIP)
#5	120		570	650				38°	30% 24P (10 SECOND DIP)
#6	70		570	650				38°	NO SMOKE-OVEN ROASTED

## NOTES

#1

#2

#3

#4

#5

#6

Date: 2/6/97

Supplied By: PEAINVILLE FARMS

UNITHERM Food Systems, Inc.										Date:	
Cooking Trial Data						Product:				Supplied By:	
Test #	Belt Speed	Cook Time	Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remarks		
			Zone 1	Zone 2							
#1		7 min	550	220					3070 24P		
#2											
#3											
#4											
#5											
#6											
NOTES											
#1											
#2											
#3											
#4											
#5											
#6											

UNITHERM Food Systems, Inc.										Date: 2/6/97
Cooking Trial Data				Product: TURKEY			Supplied By: PAINVILLE FARMS			
Test #	Belt Speed	Cook Time	Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remarks	
			Zone 1	Zone 2						
#1	71	6.5 MINUTES	570°F	650°F					30% CHAR SOL SELECT 24P	
#2	90	5.5 MINUTES	570°	650°					30% CHAR SOL SELECT 24P	
#3	90	5.5 MINUTES	570°	650°					30% CHAR SOL SELECT 24P	
#4	103	4.5 MINUTES	570°	650°					30% CHAR SOL SELECT 24P	
#5	120	4 MINUTES	570°	650°					30% CHAR SOL SELECT 24P - 10 SECOND DIP - (VS. 30 SEC)	
#6	70	6.6 MIN	570°	650°					NO SMOKE - OVEN ROASTED	
NOTES										
#1										
#2										
#3										
#4										
#5										
#6										

UNITHERM Food Systems, Inc.										Date: 2/6/97
Cooking Trial Data					Product: TURKEY					Supplied By: LEANVILLE FARMS
Test #	Belt Speed	Cook Time	Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remarks	
			Zone 1	Zone 2						
#7	70	6.6 MINUTES	570°	650°					50% MIX OF SUPPLIED SUGAR	
#8	120	4 MINUTES	570°	650°					20% CHARCOL SELECT 24P	
#9	120	4 MINUTES	570°	650°					10 SECONDS DIP 20% CHARCOL SELECT 24P	
NOTES										
#1										
#2										
#3										
#4										
#5										
#6										

January 27, 1997

Tim McConnell  
FOSTER FARMS  
520 "C" St.  
Turlock, CA 95380

*Via Fax # 209-394-6463*

Dear Tim:

It is important to read all of the notes when looking at the product. You will notice subtle changes in the process.

#### SMOKED PRODUCTS

##### Product No. 1

This was dipped in liquid smoke for 60 sec.  
Solution was Charcoal Select, 70 Smoke / 30 Water  
Oven Temp.: 265° C.  
Dwell Time: 10 minutes  
Cook Yield: 98½ percent

##### No. 2

This was dipped in liquid smoke for 60 sec.  
Solution was Charcoal Select, 50 Smoke / 50 Water  
Oven Temp.: 265° C.  
Dwell Time: 10 minutes  
Cook Yield: 98 percent

##### No. 3

The same as No. 2

U-00645

PTO-004064

No. 5

This was dipped in 30 percent Smoke / 70 percent Water

Oven Temp.: 265° C.

Dwell Time: 10 minutes

Cook Yield: 98½ percent

No. 10

This product was dipped for 30 seconds in a 30 percent Smoke concentration.

Oven Temp.: 280° C.

Dwell Time: 10 minutes

Cook Yield: 98½ percent

Fans were reversed to drive heat through the belt.

ROASTED PRODUCTS

No. 11

The dwell time for this product was increased to 20 minutes and the fans reversed to drive the energy through the belt. Yield was 93 percent.

The variables are time, temperature, and smoke concentration. The direction of the fans can deliver energy locally across the crown and through the belt. By reversing the fans on a one-zone oven, you direct more energy to the inside of the product.

I noticed that the peripheral edge of the product charred. This may be desirable or you may seek to eliminate it. This can be achieved by introducing super-heated vapor from steam. On this trial we did not use this process; however, during Gary's site visit, I will demonstrate this.

Please ring if you have any questions.

Regards,

David Howard  
President

CH465TM

U-00046

PTO-004065

UNITHERM Food Systems, Inc.										Date: January 27, 1997
Cooking Trial Data										
			Product: Turkey						Supplied By: FOSTER FARMS	
Test #	Belt Speed	Cook Time	Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remarks	
			Zone 1	Zone 2						
#1		15 min.	300 o C.	350/300	7.19	6.80	94.58%	41	Surface temp. 126 1/2 F.	
#2		15 min.	300 o C.	350/300	7.92	7.43	93.75%	29.0/43.8	Into second zone 10:39. Surface 138 o.	
#3		15 min.	300 o C.	350/300	7.63	7.31	95.81%		Too light	
#4		15 min.	300 o C.	350/300	7.07	6.76	95.68%		38 o before cooking - Too light	
#5		15 min.	300 o C.	350/300	8.91	8.55	95.96%		Skin on - Too light	
#6		15 min.	300 o C.	350/300	7.40	6.97	94.25%		Skinless	
#7		15 min.	300 o C.	350/300	9.71	9.11	93.82%		Skin on	
#8		15 min.	300 o C.	350/300	8.38	8.00	95.47%		Smoked & cured	
#9		15 min.	300 o C.	350/300	7.97	7.69	96.49%		Browned only - Skinless	
#10		15 min.	300 o C.	350/300	8.39	7.88	93.98%		Skinless	
#11		15 min.	300 o C.	350/300	7.70	7.54	97.92%		Skinless	
#12		15 min.	300 o C.	350/300	8.15	7.33	89.94%		Skinless	
#13			300 o C.	350/300	7.50	7.24	96.53%		Smoke 50/50 Charcol Supreme - In oven less than 10 min.; oven speeded up to get prop r color	
#14			300 o C.	350/300	8.08	7.77	96.16%		Smoke 50/50 Charcol Supreme - In oven less than 10 min.; oven speeded up to get prop r color	
NOTE: Crowns did not have any dextrose or super ingredients in the dell rolls.										



UNITHERM Food Systems, Inc.										Date:		
Cooking Trial Data												
Product:										Supplied By:		
Test #	Belt Speed	Cook Time	Temperatures C.		Start Weight	Cooked Weight	Yield	Internal Temp. F.	Remark			
			Zone 1	Zone 2								
#1					8.38	8.00	4.53		Smoked + Cured			
#2					7.97	7.64			Browned only skinless			
#3					8.385	7.88	6.0		SKIN ON 7.88			
#4					7.70	7.54	5.57	AM	SKINLESS			
#5				27.62	8.15	7.33	22.54		"			
#6					7.5	7.24	3.4		SMOKE 50/50 Charol Supreme			
NOTES										SMOKE 50/50.		
#1	Browned											
#2	Lead time											
#3	Speed up											
#4	Browned to get char											
#5												
#6												

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U-8215

PTO-004067

UNITHERM Food Systems, Inc.										Date:
Cooking Trial Data										
Test #	Belt Speed	Cook Time	Product:		Start Weight	Cooked Weight	Yield	Supplied By:		Remarks
			Temperatures C.	Internal Temp. F.						
			Zone 1	Zone 2						
#1		15 min.	300°	350°	7.190	6.8	5.4%	41		surface Temp 126 1/2 F
#2			300	300	7.92	7.425	6.3%	START 39.0 43.8°		IN-TEMP 411 GIVE SUGAR ZONE 10.3% surface 138°
#3					7.630	7.310	4.2%			TOO LIGHT
#4					7.005	6.76	4.3			350 b/caking TOO LIGHT
#5					8.91	8.55	4.04			SKIN ON TOO LIGHT
#6					7.395	6.970				SKINLESS
NOTES										
#1	9.71 9.180									SKIN ON
#2										
#3										
#4										
#5										
#6										

CROWN  
 \* NOTE - ~~product~~ did not have any  
 decrease in sugar ~~product~~ in the  
 deli rolls.

1/30/97

Total Unit Length 37'

Heating Length 27'

$$27' \times 12" = 324" = 32.4$$

Say 10 Min cycle

# 304

~~5 days~~  $1953^{\#} \times 6 = 11,718^{\#}/hr$  ~~product two sides~~

~~4 up~~  $1593 \times 6 = 9558^{\#}/hr \times 16 = 152,928^{\#}$   
~~17.7 per hr 1062 per hr~~

5 Days 764,640 / L

6 Days 917,568 / week

10" Centres

$$27' \text{ in } 16 \text{ inches } \times 12" = 324"$$

Concrete

Each over will hold @ 9<sup>#</sup> per sq ft  $36^{\#} \times 32.4 = 1166^{\#}$

$$4 \text{ per } \times 32.4 = 129.6 \times 6 = 777.6 \text{ per } /$$

$$1166 \times 6 (10 \text{ in}) = 6996^{\#}/hr = \text{or } 13^{\#} \text{ per } / \text{in}$$

$$1166 \times 6 = 6996^{\#}/hr$$

$$559,680^{\#} / 5 \text{ Days week}$$

$$\text{or } 671,616^{\#} / 6 \text{ Days week}$$

WB-000053

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PTO-004069

(1) 3 Pcs - N. Smoker  
 Bell Speed Settings 49.25  
1 f

39" Belt  
 7 1/2" Spindlet

1/28/97

Time 9.92  
 14 Min 9.49  
 Internal Temp Into 35°  
 1/4 Surface 156°

Center  
 9.88  
 9.47  
 2  
 151°

Rt  
 9.92  
 9.52  
 152°

Nesquite

Internal 35°

35°

35°

Burnt Spots - Top Brubaker - Burned Color

Underside - Little color development  
 - Burnt over the bar

Conclusion

- Slow speed down to 10 min

1/28/77

Test 2      Belt Speed      72

30 Sec. Smoke Dried

9.94 #

N. D.:

9.88 #

Surface

2

43"

Side

37"

Hot of Oven

9.64 # (3,027.)

9.62 #

(2,657.)

9 Min 45 in oven

1/4" Surface

116"

109"

Internal

38"

39"

Observation:

Smoked: Good Redish Tone.

Minor blistering on Top  
Smoke Steaking

Plane: Minor blistering on top

Conclusion: Reduce time to 9 min

Test 3

1/28/97

Setting 80

10 DC (1/1)

1ft

RT  
Center

Main  
Center

9.92

9.93

9.91

Time 9 Min

9.64 (2.8%)

9.68 (2.52%)

9.66 (2.

Surface  
Lat

125  
40°

115  
39

1ft: Smoke: No Smoke Struckings  
Slightly light Smoke color  
Good Uniformity  
Very minor blistering

Target: Make smoke slightly more concent.  
Reduce Zone 3 Temp by 50°F  
RT Smoke: Smoke Struckings

PTO-004072

Main: Very minor blistering

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Test #4

1/28/97

LFT

KT

Setting 80      10 DC 1/1      10 DC 2/1  
                         - Last      Time reduced by

~~9.89~~

~~9.89~~

9.92

9.89

Cooling Wt

9.67 (2.57)

9.65 (~~9.89~~ 2.43 %)

Surface

104°

121°

Internal

38°

39°

Evaluation : 10 DC 1/1

→ Eliminates the blistering  
Good Uniformity  
Slightly light smoke color  
No streaking

10 DC 2/1

→

Minor burnt spots  
Uniform color  
Some streaking

PTO-004073

WB-000057

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Test 5

304

Lgt

204

Pt

1/28/97

100 (2/1)

Setting 80

8.87

9.61 - Hnd Pmx

9.56 - Wheel

8 Min 41 sec

Out of oven

8.68

~~8.86~~

(2.22?) 9.30

(2.72?)

Surface

140

116°

Lgt

34°

34°

Evaluation of 304 : More reddish tone  
Uniformity  
Darker than expected or process.

Evaluation of 204 : Not Mn. tone color  
Pretty golden brown color

PTO-004074

WB-000058

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Test 6

304

1/28/77

Surface  
Internal

39°

33°

8.85

Setting 102

Oven Dwell Time 6 Min 47 sec

Cooked ~~Wt~~

8.67<sup>#</sup> (2.03?)

Comments

Lighter cooler  
Was sweating out of oven  
Remained ~~Wt~~ for

Test 7

304

~~Wt~~

8.88<sup>#</sup>

Setting 90

Oven Dwell Time 7 Min 48 sec

8.70<sup>#</sup> (1.91?)

Comments

~~Lighter~~ Very Good Co.

Test #8

#304

11/28/97

Setting 90 Drell Time 7 min 5  
Drench System

Time Setting 90  
Top 1st Zone 600  
Bottom 2nd Zone 650  
Top 3rd Zone 550

Smoker 100 (2/1)

Drench 34 sec (2 zones)

			<u>Wt Loss</u>	<u>% Loss</u>
1)	8.90	8.74	.16	1.80%
2)	8.87	8.71	.16	1.8%
3)	8.90	8.75	.15	1.68%
4)	8.85	8.71	.14	1.58%
5)	8.87	8.72	.15	1.69%
6)	8.91	8.76	.15	1.68%
7)	8.89	8.75	.14	1.63%
8)	8.88	8.75	.13	1.46%
9)	8.84	8.72	.12	1.36%
10)	8.77	8.74	.03	
11)	8.93	8.77	.16	1.77
12)	8.90	8.75	.15	(1.68%)
13)	8.85	8.69	.16	1.81
14)	8.94	8.79	.15	1.67
15)	8.90	8.76	.14	1.57

Evaporation: from color uniformity; Sides very light  
100% : 100% : 100% : 100%

WB-000060

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Pre test - 1 sec 50 sec drench with Last 3 zones  
7 Min 50 sec Cook color - Dark Side

PTO-004076

Test # 9

± 304

1/28/87

Time setting

90

Dwell Time

B.H.m,  $\frac{t}{2}$  zone

650'

Sonhe 100 (2/1)

Bottom 2<sup>nd</sup> zone

650

Drench 50 sec (3 zone.

Top 3<sup>rd</sup> Zinc

550

1) 8,90

2) 8.90

3) 8.85

4) 8.88

5) 8.84

Production  
Volume

44.37 <sup>#</sup> / 20"

$$37' \times 1.2'' = 444'' = 44.5'$$

5-yr  $1953^{\#} \times 7 = 13675^{\#} / \text{hr}$

4 up 180% = 35.9# = 15.93# X 2      11, 157 #/hr

178, 523# / Len

892,617 # / wh

1/29/97

## Observations

- 1/ Conveyor too light Needs to hold 16  
- Question why it shouldn't be same as the  
belt on the test unit!  
Dave talked about that

5. convert color variability & yield variability

- 1) Fan distance settings - OK, but angle can be changed  
2) Baffle blockage | to give better air on j  
side

Over temp	$M_{\text{ex}}$	572°F	300°C
Under	$M_{\text{ex}}$	670°F	350°C

PTO-004078

WB-000062

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Test 10

44 - Hickory Grove Code 52934

11/22/97

7 Min 42.5  
~~742~~

Time Setting 90  
Bottom 1st Zone 640  
Bottom 2nd Zone 650  
Top 3rd Zone 850

Dwell Time  
Smoke 100 (2/1)  
Smoke Dwell 70 sec (4 sec  
10" on center

1	9.86	9.686	1.767
2	9.92	9.78	1.417
3	9.87	9.81	1.417
4	9.95	9.734	1.387

Too light

4 pcs run in front  
Ahead 4 pcs run  
4 pcs run after

PTO-004079

WB-000063

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Test 11 44 - Hickory Code 57934

1/29/92

Time setting 80  
Bottom Air 1st Zone 650  
Bottom Air 2nd Zone 670  
Top Air 3rd Zone 550

Dwell Time 8 Min 40 s  
Smoke 100 (2/1)  
Smoke Dwell 70 sec (4 Zone)

1)	9.88	9.646	2.37?	Good on one side
2)	9.89	9.70	1.92?	Better but to 1.5
3)	9.90	9.716	1.86?	
4)	9.91	9.736	1.75?	Lightest

PTO-004080

WB-000064

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11/29/97

Test # 12 44 Hickory Code 57934

Time Setting 76 ↓

Dwell Time 9 min

Bottom 1st Zone 650

Smoke 100 (2/1)

Bottom 2nd Zone 670

Smoke Dwell 70 Sec (42 min)

Tip 3rd Zone 570 ↑

1)	9.93	9.676	2.56%
2)	9.93	9.720	2.11%
3)	9.91	9.708	2.04%
4)	9.90	9.71	1.92%

4 Per wide

4 Per Test

4 Per wide

Adjust buffer

To Light

PTO-004081

WB-000065

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TEST 13

44 Hickory 57934

1/29/9.

Objective: See Zone 2 & 3 to look at ratio of Top + Bottom

Time Setting 46

Dwell time 9 Min 40.

Bottom Zone 2 - 670

Smoke 100 (2/1)

Top Zone 3 - 570

Smoke Dwell 70 Sec (42.)

1) 9.90	9.60	3.03%
2) 9.92	9.64	2.78%
3) 9.91	9.628	2.84%
4) 9.89	9.628	2.65%

All darker color - Maybe too dark  
Need better

PTO-004082

WB-000066

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Test 14

44 Hickory

5-7934

1/29/97

Time setting 76

~~100~~

Dwell time 9 Min 30

Smoke 100 (2/1)

Smoke Dwell 70 sec (42)

Top Zone 1 570

Bottom Zone 2 670

Top Zone 3 570

1	9.90	9.646	2.567
2	9.89	9.626	2.677
3	9.76	9.524	2.427
4	9.91	9.676	2.367

Product before and after

Evaluation

At 4 on color chart  
Top darker than sides

PTO-004083

WB-000067

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Test 15

44 Kirby 57934

11/29/97

Time Setting 48

Dwell time 9 min 20.

Smoke 100 (2/1)

Smoke Dwell 76 sec (420)

Top Zone 1 570°F  
Bottom Zone 2 670°F

①	9.91	9.644	2.637.
②	9.94	9.704	2.377.
③	9.86	9.876	2.377.
④	9.91	9.616	2.477.

Product bc

Evaluation : More uniformity of color  
Very good color

PTO-004084

WB-000068

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Test 16

44 Hickory 57934

1/29/41

Time Setting 48

Top Zone 1 570°

Bottom Zone 2 670°

Dwell time 9 min 34 s

Smoke 100 (2/1)

Smoke Dwell 70 sec (4) 200

Change in belt position: side ways

Belt Loading 17" to 18" for 2

122	1)	9.88	9.624	2.59?
116	2)	9.93	9.712	2.20?
	3)	9.86	9.642	2.21?
	4)	9.95	9.736	2.15?

Evaluation: Uniform color

PTO-004085

WB-000069

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Test 27

444 - # 5-7934

1/30/97

Product Temp Core 40-42'

Time Setting	76	Dwell Time	9 min
Top Zone 1	570	Snake	100 (2/1)
Bottom Zone 2	670	Snake Dwell	70 sec (42-45)
Bottom Zone 3	670		

1)	9.91	9.654	2.58%
2)	9.98	9.724	2.56%
3)	9.69	9.436	2.62%
4)	10.04	9.808	2.31%

Evaluation - Very uniform color

Fur side Pca is darker

Fur side lighter

Attraction color

PTO-004086

WB-000070

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Test 18

444 - #57974

1/30/97

Enter

Time Setting 72

Dwell Time 9 Min 30

Top Zone 1 570 (Temp drops)

Smoke 100 (2/1)

Bottom Zone 2 670

Smoke Dwell Time 70 sec (4 gr)

Bottom Zone 3 670

1) 9.77 9.418 3.6%

2) 9.95 9.658 2.93%

3) 9.81 9.532 2.83%

4) 9.88 9.622 2.61%

Evaluation: Slightly Darker Cooler

PTO-004087

WB-000071

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TEST 19

50204 - Hickory

1/30/97

Time Setting	72	Drill Time	9 Min 30
Top Zone 1	570	Temp Drop	Smoke 100 (2/1)
Bottom Zone 2	670	Smoke Drill	70 sec (42)
Bottom Zone 3	670		

	1)	9.53	9.266	2.77 ?
Rise	2)	9.43	9.172	2.73 ?
	3)	9.53	9.246	2.98 ?
	4)	9.55	9.384	2.78 ?

Evaluation: Color little darker than 44's  
Left side darker

PTO-004088

WB-000072

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Test 20

302-304 Hickory

1/30/87

Time Setting	72	Dwell Time	9 Min 35 s
Top Zone 1	570 Temp Degr	Smoke 100 (2/1)	
Bottom Zone 2	670	Smoke Dwell 70 sec	(4 Zone)
Bottom Zone 3	670		

1)	8.83	Hit side of machine		
Top H.100	2) 8.70	8.534	1.90%	Liquid Smoke in h.c.
	3) 8.85	8.680	1.92%	
Top H.100	4) 8.84	8.682	1.79%	Liquid Smoke in h.c.
Top H.100	5) 8.82	8.656	1.86%	Liquid Smoke in h.c.

Evaluation: More of crowning effect  
Overall color good  
Product too close

Product too wide for 5 rows  
Some pieces have 8" Footprint

PTO-004089

WB-000073

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Test 21

302-304 Hickory

1/30/97

Time Setting	72	Dwell Time	9 Min 30 sec
Top	Zone 1 570	Smoke	160 (2/1)
Bottom	Zone 2 670	Smoke Dwell	20 sec (4 zones)
Bottom	Zone 3 670		

1) 8.83	8.636	2.19?
2) 8.71	8.538	1.97?
3) 8.71	8.538	1.97?
4) 8.84	8.682	1.79?
5) 8.78	8.552	3.05? ?

6) 8.71	8.520	2.18?
7) 8.83	8.648	2.06?
8) 8.70	8.546	1.77?
9) 8.72	8.554	1.90?

4 Wides give more uniform side color  
Color lighter than 304 Control

PTO-004090

WB-000074

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Test 22

44 Breast  
Mesquite Smoke

1/30/97

Time Setting 72

Drill Time 9 Min 30 Sec

Top Zone 1 570

Hand Dip 45 Sec

Bottom Zone 2 670

10 DC Mesquite

Bottom Zone 3 670

1/1

1) 10.03 9.762 2.67%

2) 9.29 9.006 3.05%

3) 9.93 9.678 2.53%

4) 9.97 9.69 2.80%

2/1

5) 9.97 9.666 3.05%

6) 10.00 9.752 2.48%

7) 10.05 9.774 2.74%

8) 10.00 9.734 2.66%

Evaluation: 2/1 Slightly Darker  
Overall too Light

PTO-004091

WB-000075

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Test 23

44 Burst  
Meyate Smoke

1/30/97

Time Setting 63

Direct Time 10 Min 45

Top Zone 1 570

Bottom Zone 2 670 10 DC 2/1 M:spite Smoke

Bottom Zone 3 670 45 Sec Hard Dig

~~9.93~~  
1) 9.93 9.57 3.62?

2) 10.60 10.268 3.13?

3) 10.23 9.89 3.32?

4) 9.10 8.82 3.08?

Evaluation: Dark than prior test # 22

Still on light side of color range

Test #25

76 Best

1/30/97

Spool Setting 72

Dwell Time 9 Min 27

Top Zone 1 570

Mailose ~~Machine~~ 1/1

Bottom Zone 2 670

45 Sec Hand Dip

Bottom Zone 3 670

Area Conting Loss

1) 8.44

8.126

3.72%

2) 9.38

9.092

3.07%

3) 9.27

8.982

3.00%

4) 10.34

10.046

2.84%

Evaluation:

The target color

More uniform than present system

5) 9.10

8.592

5.58% Loss

No treatment - In 3<sup>rd</sup> roll then ran twice

Golden brown with black highlights

PTO-004093

WB-000077

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Test 24

44 Breast  
Marquie Sonde

11/30/97

Time Setting 6.3

Dwell Time 10 Min 45

Top Zone 1 572

Bottom Zone 2 670

Bottom Zone 3 670

1 Part Super

1 Part 10DC

1 Part White

Rich Hall

40% More color

1/2 the cost

45 sec Kind Application

1) 9.67 9.326 3.567.

2) 9.84 9.504 3.417.

3) 9.96 9.622 3.397.

4) 9.86 9.572 2.927.

Evaluation: Color closer to target

Left piece on target color

Bottom too dark

Test Redo with partial loaded belt

1:31 ① 9.95 ~~9.556~~ 3.187.

② 9.87 ~~9.626~~ 3.267.

③ 9.93 ~~9.614~~ 2.797.

④ 9.89 ~~9.642~~ 2.907.

⑤ 9.96 9.640 2.977.

⑥ 9.51 9.246 2.787.

⑦ 9.96 9.676 2.857.

⑧ 9.92 9.644 2.787.

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WB-000078

PTO-004094

Test 26

57942 ~~579~~ But Test

1/30/97

Speed Setting 72

Dwell time 9 Min 27 sec

Top Zone 1 - 570

100 45%

Bottom Zone 2 - 670

Nail osc ~~Antic~~ 5%

Bottom Zone 3 - 670

Water 50%

Hand Dip 45 Sec

N. W. to

Too light in color

PTO-004095

WB-000079

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